

**\*76129\***

Monday, November 07, 2011 11:10:05 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*4\***

**\*4\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|                 |                     |
|-----------------|---------------------|
| <b>Draw Nbr</b> | <b>Revision Nbr</b> |
| D2602           | Rev B               |

0.00

100

**\*100\***

## FLOW WATER JET

0.00

### Waterjet

## Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2602 \*\*\*\*\*Same Cutting File for -1 & -2 \*\*\*\*\* Dwg

2024.040

Rev: 6 Prog Rev: 6 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

| W/O: |      | WORK ORDER CHANGES |                  |    |      |     |                                     |                          |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |                    | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |                  |    |      |     |                                     |                          |
|      |      |                    |                  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 76129

**\*76129\***

Page 2

Monday, November 07, 2011 11:10:05 AM

Item ID: D2602-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Console Side, 206 Console  
 Start Date: 11/7/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/16/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><b>*130*</b><br>Brake NC<br>Brake NC         | NC BRAKE<br><br>Memo<br>1-Deburr if necessary 2-Form as per Dwg D2602 | 0.00<br><br>0.00     |         |        |              | (1)           |               |                  | 8/12/05/15     |
| 140<br><b>*140*</b><br>QC<br>Quality Control        | QC5- Inspect part completeness to step on W/O<br><br>Memo             | 0.00<br><br>0.00     |         |        |              | (+40)<br>-2   | 4             |                  |                |
| 150<br><b>*150*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo                   | 0.00<br><br>0.00     |         |        |              | 4             | 4             | BR' 125-15       |                |

| W/O: |      | WORK ORDER CHANGES |                  |    |      |     |                                     |                          |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |                    | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |                  |    |      |     |                                     |                          |
|      |      |                    |                  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 76129****\*76129\***

Page 3

Monday, November 07, 2011 11:10:05 AM

Item ID: D2602-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Console Side, 206 Console

Start Date: 11/7/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

4

SB  
14/05/15

170

Identify as per dwg & Stock Location: GL

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

4

SB  
14/05/15

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/15/16

MF  
12-05-16

| W/O: |      | WORK ORDER CHANGES |                  |    |      |     |                                     |                          |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |                    | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |                  |    |      |     |                                     |                          |
|      |      |                    |                  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 07, 2011 11:10:09 AM

Page 1

Work Order ID: 76129

\*76129\*

Parent Item: D2602-2

\*D2602-2\*

Parent Item Name: Console Side, 206 Console

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP E04.02.25ReformatKJ/RF

Note: Issue with part number D2602-1

IPP Rev:E Now On Waterjet 07-03-22 JLM

IPP Rev:F RevB as per dwg ECN1059 DD vereified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.040                    |                        | Purchased     |             | No                  |                  | 100             | sf                 | 76.8184        | 1.3472      | 5.672421     |               |                |        |

\*M2024T3S 040\*

2024-T3 .040 sheet

\*\*

Location

Loc Qty

Loc Code

MAT022

76.818421

117684

76.818421

117684

Jm  
12-5-14

| W/O: |      | WORK ORDER CHANGES |                  |    |      |     |                                     |                          |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |                    | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |                  |    |      |     |                                     |                          |
|      |      |                    |                  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76129

10/11/07

**D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)  
(D2602-2 OPPOSITE)**

RELEASED  
07-12-12/14

**D2602-1F FLAT PATTERN**

BEND LINE

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

| B          | ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES | DC  | 07.11.07     |
|------------|---|---|--------------|
| A          | D2602 WAS D206-547-211/22   | BW  | 97.10.22     |
| REV.       | DESCRIPTION   | BY  | DATE         |
| DESIGN     | JB  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | JC  |   |              |
| CHECKED    | LE  | DRAWING NO.   | REV. B       |
| MFG. APPR. | DA  | D2602   | SHEET 1 OF 1 |
| APPROVED   | JP  | TITLE   | SCALE        |
| DE APPR.   | JP  | CONSOLE SIDE  | 1:3          |
| DATE       | 07.11.07  | COPYRIGHT © 1997 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |

| W/O: |      | WORK ORDER CHANGES |                  |    |      |     |                                     |                          |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |                    | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |                  |    |      |     |                                     |                          |
|      |      |                    |                  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries